Work Orde				*106	64	.9*			•				Page, 1
Item ID: Revision ID:	D4009-041		A	Accept	*/	1900	040	100	n *	Setup	Start	ıv.	S1*
Item Name:	Bonding Braid										Stop	*N:	S2*
Start Date:	9/11/13	Start Qty: 20.00	*20*		(Cust Item I	D:						
Required Date: Reference:	9/11/13	Req'd Qty: 20.00	*20*		C	Customer:							
Approvals:	Process Plan	1: MLJ	Date: 13-09-13	Tooling:		D:	ate:			Run	Start Stop	*NI	R1*
	QC:			SPC (Y/N):		Da	ate:				Stop	*NI	R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accep Qty	t Re	•	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr											
D4009	Α												
100				0.00									P
100 Small Fab		Memo		0.00					200	<u> </u>			5/1
Small Fab			s per dwg D4009									/	
110 *110* QC Quality Control		QC5- Inspect part comp Memo	pleteness to step on W/O	0.00 27 1-89 0.00 13 9	13				20				
120		Identify as per dwg & Si	tock Location: <u>ST24</u> 2	0.00					2/10	d	S	12 /	va 19
120 Packaging Packaging		Memo		0.00					<u> </u>	× \ 2		15-6	9-18

									DQA:	Date:			
NCR: Y	es / No				WORK ORDER NON-	CONFO	RMANCE /	UPDATE		· · · · · · · · · · · · · · · · · · ·			
									QA Closed:	Date:			
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N	lo				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	Pro Rec/Sto	Engineering Quality Other			
Root					iption of work order update	Initia	l l	Action	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng [Description	Date	Verification	QC Inspector		
Doc/Data	_	Ì											
Equip/Tooling													
Operator	_												
Material													
Setup Other	_												
Process													
Supplier	\dashv												
Training													
Unapproved									·				
	!				F	AULT CA	TEGORY				•		
Landir	ng Gear				General								
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced		
	Centre N	ot Conce	ntric to (o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged	—	ection Incomple		Part Incorre		Weld		
	Crushed/	'Crimped		<u> </u>	Burrs	Instr	uctions Incompl	ete/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs				Contamination	$\boldsymbol{\vdash}$	ntenance		Part Moved				
ļ	Heat Trea			ļ	Countersink	\vdash	abeled		Positioned \		1		
	Inspectio				Cut Too Short	Misr			Power Loss/	'Surge	Other		
	Ripples ir			ļ	Drill Holes	Offs							
	Torque V	error of		۱ <u> </u>	Drawing		of Calibration						
	Turning S	Sequence		L	Finish	Out	of Sequence						

Outside Dimensions

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 106649 September-11-13 11:12:40 AM				*106	649*							Page 2
Item ID: Revision ID: Item Name:	D4009-041 Bonding Brai	d		Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	14.	S1* S2*
Start Date: Required Date: Reference:	9/11/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	ID:				G		
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	"	R1* R2*
Sequence ID/ Work Center I	D	Operation Description OC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qty	•	Reject Number	Insp. Stamp
130		Memo		0.00				M	L5_	_\	-09-	1_1

Quality Control

MB-0918

										•	DQA:	Date	:
NCR:	res /	No				WORK ORDER NON-	COI	NFORI	MANCE / UP	DATE	QA Closed:	Date	
						<u> </u>					QA Closed.	Date	
Work Orde	sř.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					·····	Rework Scrap			Skid-tube Crosstube Machining Small Fab			Water Jet d. Eng. Coor.	Engineering Quality
NCR N						Use-as-is Thermofor			· —	ng Finishing Rec/Store/Packag			Other
Root		1			Descri	ption of work order update	Ti	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material												<u>.</u>	
Setup											,		
Other		Ì										<u>F</u>	
Process											•		
Supplier	Ш		:										
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Unapproved		,					\perp						
						F	AUL	T CATE	GORY				
Landi	ng Gea	r			_	General	_	•			,	_	_
	_	nding			ļ	Bend	L	Grain			Ovalized	<u> </u>	Pressure/Forced
	$\boldsymbol{\vdash}$		t Concer	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	<u> </u>	Temperature/Cure
	⊢—	acks				Broken/Damaged	\perp	4 '	on Incomplete		Part Incorred	<u> </u>	Weld
	$oldsymbol{oldsymbol{ ext{H}}}$	ushed/C	rimped		<u> </u>	Burrs		1	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	 	ffs				Contamination	\perp	Mainte			Part Moved		
	\vdash	at Treat				Countersink	\perp	Mislabe			Positioned V		7
:			Strip in	Tube	_	Cut Too Short	\perp	Misread	I		Power Loss/	Surge	Other
	— '	oples in				Drill Holes	L	Offset					
	To	rque W	aves in E	xtrusio	n	Drawing	1	Out of 0	Calibration				

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish Folio September-11-13 11:12:40 AM

Work Order ID:

106649

Parent Item:

D4009-041

Parent Item Name:

Bonding Braid

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP rev A 10.02.02 new issue Prelim EC verified by:DD

IPP Rev:B 10.05.03 as per ECN10-

	D.D.	. ~ 1	1	\mathbf{r}
567	1111	verified	hs	J (
JU2	עע	VCIIIICU	U	y . L. C

	562 DD verified b	y:EC					_						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4009-1		Manufactured	No			100	Each	59.0000	2	40	4/1	3/1	0/1-
Terminal End											J) 1	5/0,	7/1+
				Location		Loc Qty	L	oc Code					
				ST083		59							,
				100	332	59			4	0_	0	1	
D4009-3		Manufactured	No			100	Each	7.0000	. 1	20	المركب	13/	19/12
Ground Strap									• •			<u>, </u>	<u> </u>
				Location		Loc Qty	L	oc Code				•	
				GA	00	5						067	43 (1
				858 985		4					B1	06 T	
				ST084	00	2				—	J'		
				725	36	2					0		/ /
D4009-5		Manufactured	No			100	Each	1.0000	1	20	ركر	(-/	20/17
Ground Strap									cae: :he	<	//	1/3/0	07/17
				Location		Loc Qty	<u>L</u>	oc Code			// .	~ _	x > 6
				ST084		1					15/1	770	63 (4
		•		725	37 `	1					. //	_	/ /
D4009-7		Manufactured	No			100	Each	61.0000	1	20	9/	17/	20/12
Γab									cay		/		1/17
·	`			Location		Loc Qty	<u>L</u> o	oc Code				•	/
				ST083		61							•
				621	37 44 	2 59				$\overline{\triangle}$			
				930	44 🕶	39							

										DQA:	Date	e:
NCR: Y	es / No	. •			WORK ORDER NON-O	COI	NFORM	MANCE / UPDATE		0465	Date	
,										QA Closed:	Date	2:
Work Orde	àr.				DISPOSITION			AGAIN	ST DI	PARTMENT	/PROCESS	
Work Orde					Rework	1		Skid-tube Crosstu	be	7	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining Small F	_	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	Therm	noforming Finishi	ng	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update			Large Fab Composi	te]	Supplier	
		,			<u> </u>					·		·
Root					ption of work order update	1	Initial	Action		Sign &		
Causè	Date	Step	Qty	. (or Non-conformance	Ct	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						İ						
Operator											•	
Material												
Setup												1
Other												
Process	_	1				1	·					
Supplier							:					
Training		ļ										
Unapproved			<u> </u>			<u> </u>						.1.
					F.	AUI	T CATE	GORY				
Landi	ng Gear				General		1		_	7	-	
	Bending			_	Bend	_	Grain		\vdash	Ovalized	·	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa			Over/Under	-	Temperature/Cure
	Cracks	-		<u> </u>	Broken/Damaged		4 '	on incomplete	<u> </u>	Part Incorred	⊢	Weld
	Crushed/	Crimped		<u> </u>	Burrs	_	1	ions Incomplete/Unclear	_	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte		\perp	Part Moved		
	Heat Trea			<u> </u>	Countersink		Mislabe		\perp	Positioned V	_	- 7
•	Inspectio	-	Tube		Cut Too Short	\vdash	Misread	I	L	Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-11-13 11:12:40 AM

Work Order ID:

106649

Parent Item:

D4009-041

Parent Item Name:

Bonding Braid

D4009-9 Receptacle Manufactured No

103158

72675 85979

Location

ST084

100

Loc Qty

42

38

Each

42.0000

Loc Code

Start Qty: 20.00

Start Date: 9/11/13

2

20

\$ 103158 18x

Required Date: 9/11/13

Required Qty: 20.00

September-11-13 11:12:40 AM

Shop Packet Print

Page 2

										· D	QA:	Da	te:	
NCR: Y	es / No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE	QA Clo	sed:	Da	te:	
M- 1 0 -1-					DISPOSITION				AGAINST DE			···		
Work Orde Part N					Rework Scrap Use-as-is		ı	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
NCR N	0				Work Order Update]		Large Fab	Composite	, Rec	,310	Supplier	$\boldsymbol{-}$	Other
Root	į.				ption of work order update	1	nitial		tion	Sign				·
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Dat	e	Verificatio	n	QC Inspector
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quip/Tooling				i										
Operator	_													
Material													1	
Setup	_	:												
Other		l								i			l	
Process		1											l	
Supplier														
Training														
Unapproved												ļ		
					F	AUL	T CATE	GORY						·
Landir	ng Gear				General		_			_				
	Bending				Bend	L	Grain			Ovalize	d			Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/U	nder	tolerance		Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Inc	orre	ct	Ш	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lo	st/Mi	issing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Mo	oved			
	Heat Trea	at			Countersink		Mislabe	eled		Position	ned V	Vrong		
İ	Inspectio	n Strip in	Tube		Cut Too Short		Misread	ł		Power	Loss/	Surge		Other
	Ripples in	n Bend			Drill Holes		Offset		<u> </u>					
	Torque V	Vaves in E	Extrusio	n 🗌	Drawing		Out of 0	Calibration						

Out of Sequence

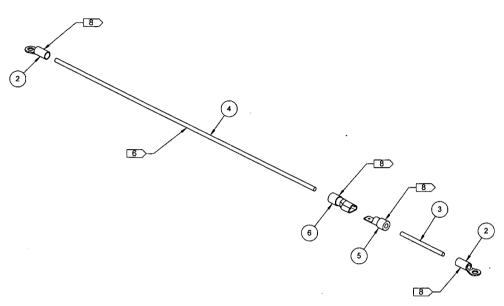
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	Х	D4009-041	BONDING BRAID	JCA-M47-4-01
2	2	D4009-1	TERMINAL END	
3	1	D4009-3	GROUND STRAP	
4	1	D4009-5	GROUND STRAP	
5	1	D4009-7	TAB	
6	1	D4009-9	RECEPTACLE	



D4009-041 BONDING BRAID

106649 MC3

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4009-041" AND B/N USING D2729-1 LABEL INSTALLED WITH D2182-045 HEAT SHRINK
7) WEIGHT: N/A
8) USE CRIMPING TOOL P/N 59824-1

NEW ISSUE DESCRIPTION DATE REV. DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN DRAWN CHECKED DRAWING NO. REV. A D4009 MFG. APPR. SHEET 1 OF 5 TITLE APPROVED SCALE **GROUND STRAP** DE APPR. DATE 10.02.05

3

SPATO . AGINE FRIMG OF TROUBED COPY , TO INTERIORENT OWNER STOREE

D